

8/15

Work Order ID 70513



Page 1

Friday, June 10, 2011 11:25:59 AM

Item ID:	D3914-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Long Basket Lid Assembly (350)					
Start Date:	6/10/2011	Start Qty:	1.00		Cust Item ID:	
Required Date:	6/15/2011	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:		Date:	11-06-10	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3914	B

100 Weld per dwg A/R S.S. rod Batch: M115778 0.00

Large Fab

Memo

0.00

Large Fab

1- assemble ribs , weld as per dwg D3914 using DT9607A
 2- weld hinge (3) and Mounting brackets as per dwg D3914
 inspect before welding mesh
 3- tack weld mesh on basket as per dwg D3914
 ***make sure to place mesh correctly on lid, check with label plate before
 tacking mesh***

11.06.17

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00



QC

Memo

0.00

Quality Control

6/11.06.20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Setup Start



Revision ID:

Stop



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Start Date: 6/10/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/15/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC

Quality Control

QC6- Inspect dimensions to drawing

0.00

Memo

0.00

8/11/2012

1

130



Powdercoat

Powder Coating

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00

M115128.

Memo

0.00

*** mask sides of hinge prior to powdercoat***

Start Time: 8:30

Oven Temperature: 320

Finish Time: 4:20

1

BL 11-6-20

140



HandFinish

Hand Finishing

Wing Walk as per dwg QSI005 4.4 Batch 117863

0.00

Memo

0.00

1- Mask data plate and apply wing walk on outside surface of mesh as per dwg

2- Install placard and label as per dwg

***Mask label plate to size of label, use scotchbrite red pad to lightly sand area for label, apply label ***

1

BL 11-6-20

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Required Date: 6/15/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

1 d 11/06/21

160

Identify as per dwg & Stock Location

0.00



Packaging

Memo

0.00

Packaging

G.A
w/o
70507

EP 11/06/21

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/06/21
mf
11-06-21

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Picklist Print

Friday, June 10, 2011 11:26:05 AM

Page 1

Work Order ID: 70513

Parent Item: D3914-041

Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 6/10/2011

Required Date: 6/15/2011


Start Qty: 1.00

Required Qty: 1.00


Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC
as per dwg revB DD 10.08.18 verified by:EC

IPP Rev:B


Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2581  Mounting Bracket		Manufactured	No			100	Each	74.0000	2	2		11.06.13	
---	--	--------------	----	--	--	-----	------	---------	---	---	--	----------	--

Location	Loc Qty	Loc Code
WA	74	
68964	6	
69258	28	
69739	40	

D3914-1  Rib		Manufactured	No			100	Each	8.0000	2	2		11.06.13	
--	--	--------------	----	--	--	-----	------	--------	---	---	--	----------	--

Location	Loc Qty	Loc Code
WA006	8	
69063	4	
69520	4	

D3914-7  Rib		Manufactured	No			100	Each	8.0000	2	2		11.06.13	
--	--	--------------	----	--	--	-----	------	--------	---	---	--	----------	--

Location	Loc Qty	Loc Code
WA	4	
70335	4	
WA006	4	
69729	4	

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Parent Item: D3914-041

Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 6/10/2011

Required Date: 6/15/2011

Start Qty: 1.00

Required Qty: 1.00

D4016-3
Hinge Half, Lid

Manufactured No

100 Each

7.0000

3

3

Location

Loc Qty

Loc Code

WA

7

69164

7

D4018-5
Rib

Manufactured No

100 Each

19.0000

9

Location

Loc Qty

Loc Code

WA005

19

67041

14

69726

5

D4020-5
Mesh (350 Basket Long, Lid)

Manufactured No

100 Each

1.0000

1

1

Location

Loc Qty

Loc Code

WA

1

68234

1

D4021-3
Data Plate

Manufactured No

100 Each

1.0000

1

1

Location

Loc Qty

Loc Code

WA

1

69724

1

D4035-041
Lid Rib Assembly, Fwd (350 Basket)

Manufactured No

100 Each

0.0000

1

1

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Page 3

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Parent Item: D3914-041



Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 6/10/2011

Required Date: 6/15/2011

Start Qty: 1.00

Required Qty: 1.00

D4035-043

Manufactured No

100 Each

2.0000

1

1



Lid Rib Assembly, Aft (350 Basket)



11.06.13

Location

Loc Qty

Loc Code

WA006

2

2

67375

D2728-3

Manufactured No

140 Each

0.0000

1

1



Dart Logo label



Dart Aerospace Ltd

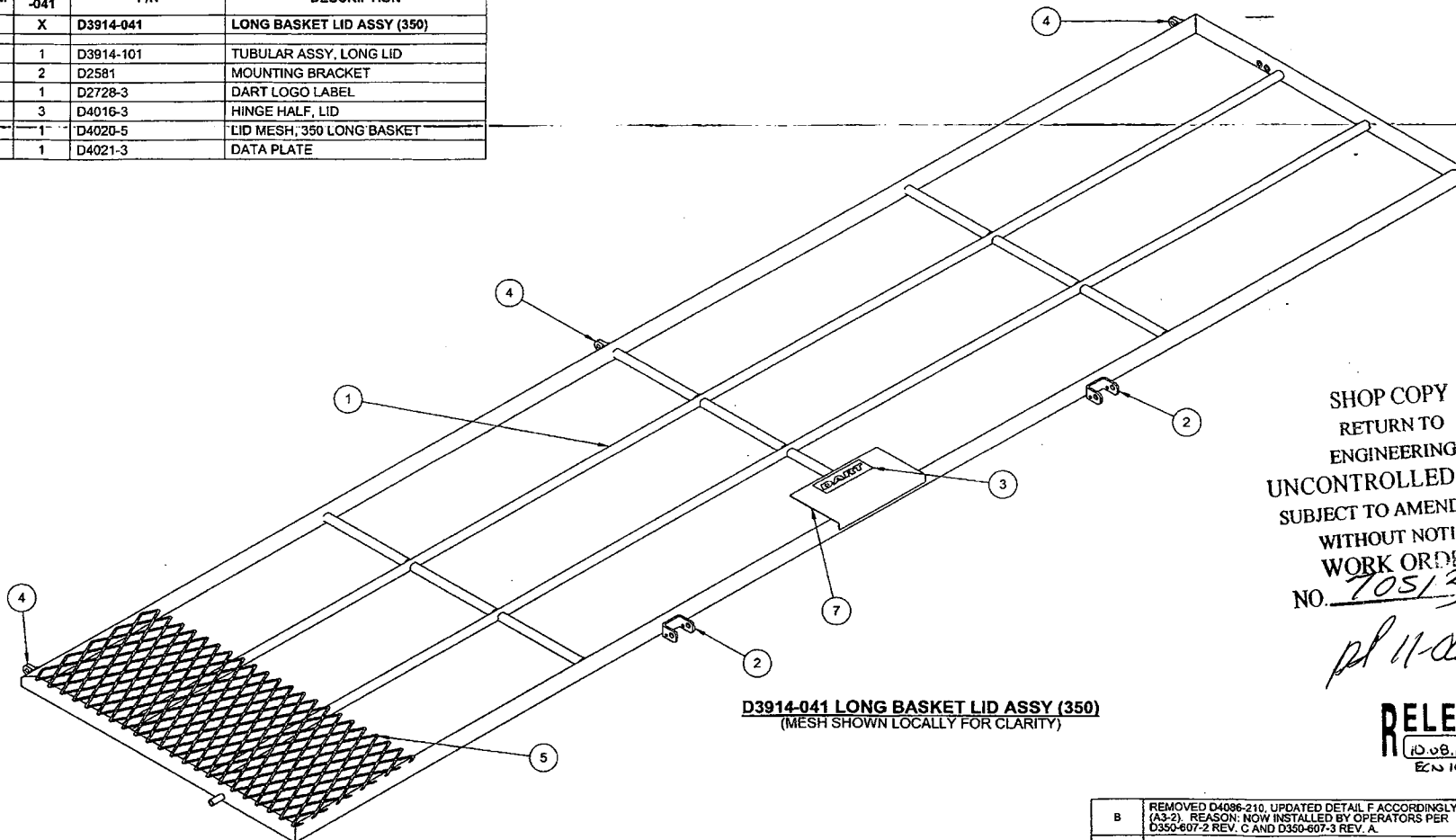
W/O:		WORK ORDER CHANGES					
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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR: Yes No** **DQA:** _____ **Date:** _____
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ITEM	QTY	P/N	DESCRIPTION
	X	D3914-041	LONG BASKET LID ASSY (350)
1	1	D3914-101	TUBULAR ASSY, LONG LID
2	2	D2581	MOUNTING BRACKET
3	1	D2728-3	DART LOGO LABEL
4	3	D4016-3	HINGE HALF, LID
6	1	D4020-5	LID MESH, 350 LONG BASKET
7	1	D4021-3	DATA PLATE



D3914-041 LONG BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 70513

pl 11-05-10

RELEASED
10.08.17
ECN 10-596

B	REMOVED D4086-210, UPDATED DETAIL F ACCORDINGLY (A3-2). REASON: NOW INSTALLED BY OPERATORS PER D350-607-2 REV. C AND D350-607-3 REV. A.	MB	10.08.05
A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	ALS		
DRAWN	SC		
CHECKED	SC		
MFG. APPR.	SC		
APPROVED	SC		
DE APPR.	SC		
DATE	10.08.05		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3914 TITLE LONG BASKET LID ASSY (350) SCALE NTS COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

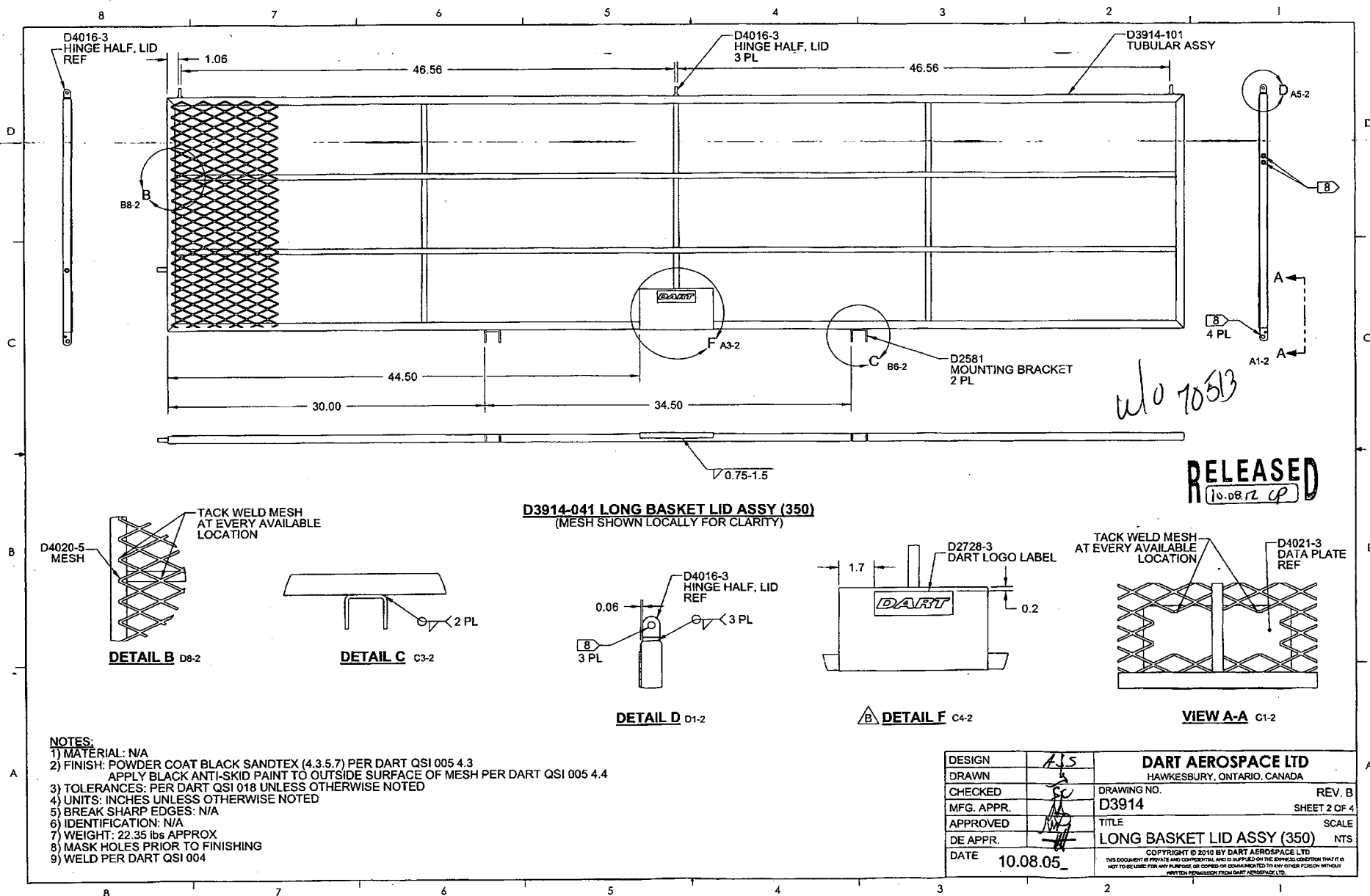
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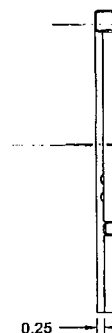
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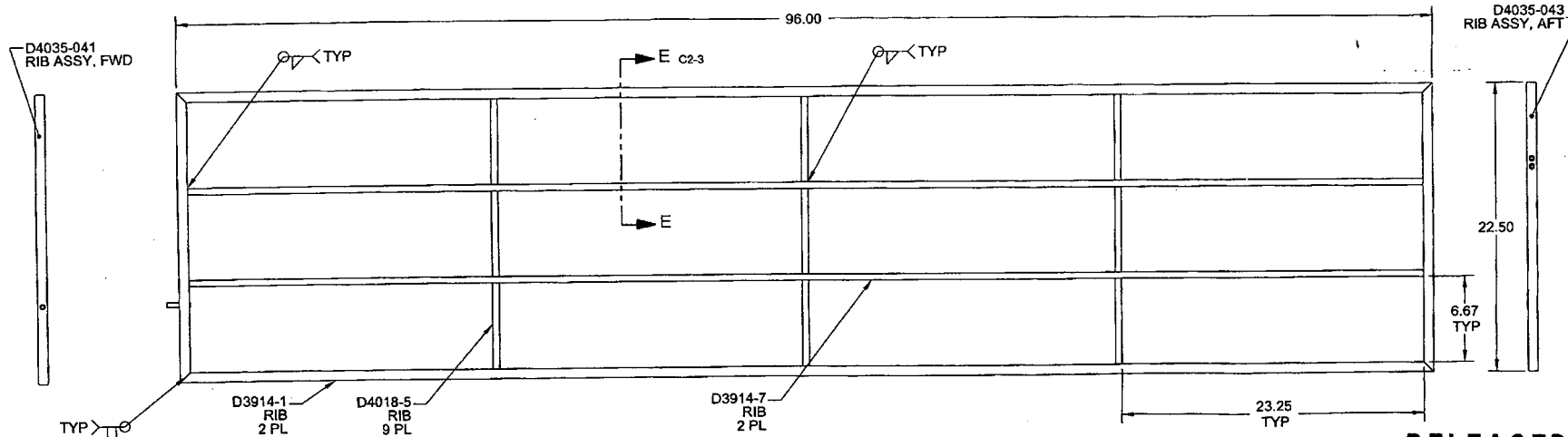
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ITEM	QTY -101	P/N	DESCRIPTION
	X	D3914-101	TUBULAR ASSY, LONG LID (350)
1	2	D3914-1	RIB
2	2	D3914-7	RIB
3	9	D4018-5	RIB
4	1	D4035-041	BASKET LID RIB ASSY, FWD
5	1	D4035-043	BASKET LID RIB ASSY, AFT



SECTION E-E C5-3



8 D3914-101 TUBULAR ASSY, LONG LID

RELEASED
10-08-12

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 14.10 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D4018-101
- 9) WELD PER DART QSI 004

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	RC	DRAWING NO.	REV. B
MFG. APPR.		D3914	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET LID ASSY (350)	NTS
DATE	10.08.05	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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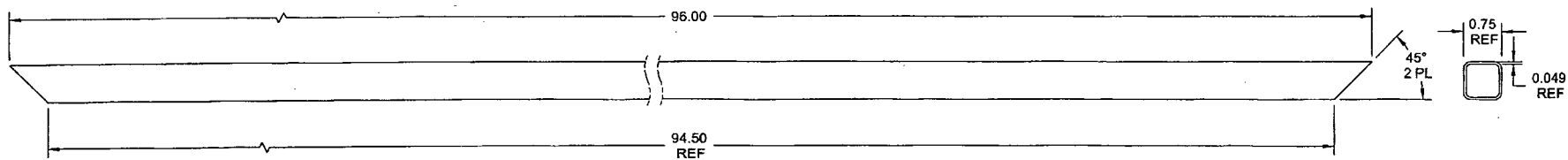
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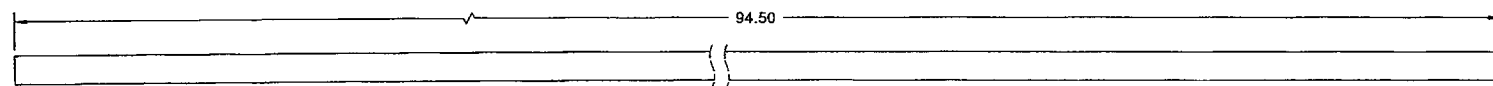
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W/O 70513



D3914-1 RIB



D3914-7 RIB

NOTES:

- 1) MATERIAL -1: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049
- 7: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE ASSEMBLED WEIGHTS

RELEASED
10.08.12 GP

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DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	SC	DRAWING NO.	REV. B
MFG. APPR.	WJP	D3914	SHEET 4 OF 4
APPROVED	WJP	TITLE	SCALE
DE APPR.	WJP	LONG BASKET LID ASSY (350)	NTS
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